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RBE350A94-2720-00

Job Sheet 195067



Part No: RBE350A94-2720-00

Job Qty: 1 pcs

Part Name: Handle, Rotary Adjustment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 7/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 11876*

Note: DWG RBE350A94-2720-00 Rev. 2 IPP Rev. A 18.09.05 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	7/2/19		0.00	0.13	Small Fab - 1		
							Small Fab - 2		<i>MLC</i>
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	7/2/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	1 pcs	7/2/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



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Container No: S183762



Part: RBE350A94-2720-00

Job No: 195067

Serial No/Batch: S183762

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 05/24/19

DAS

MAY 28 2019

40
9-89

					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - FG - 21	21
					QC 21 - FG - 70	21
					QC 21 - SA - 53	9-ss
140 QC 21 - FG	1 pcs	7/2/19	0.00	0.00		

GA141B

Part Op 100 - (Small Fab) 1-Assemble as per DWG. ***Do NOT bond -1 to -11 as per note 2, it's a typo.*** 2-Bond -15 to -11 and Descriptions: to -1 using Loctite 495.

110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3855K24	Knob, Ø1-1/4, 1/4-20 X 1-3/16 Color: Black	1 Ea (1 ea)	100-Small Fab - 1	5109082
91090A107	Washer, Ø.266 I.D., Ø.875 O.D.	1 Ea (1 ea)	100-Small Fab - 1	5109088
92735A450	Clevis Pin, Ø3/8 X 1-1/2"	1 Ea (1 ea)	100-Small Fab - 1	5109017
97633A170	External Retaining Ring, 3/8	1 Ea (1 ea)	100-Small Fab - 1	5109087
RBE350A94-2720-00-1	Handle Weldment	1 pcs (1 ea)	100-Small Fab - 1	5109126
RBE350A94-2720-00-15	Pad	2 pcs (2 ea)	100-Small Fab - 1	5183440

Job Allocations

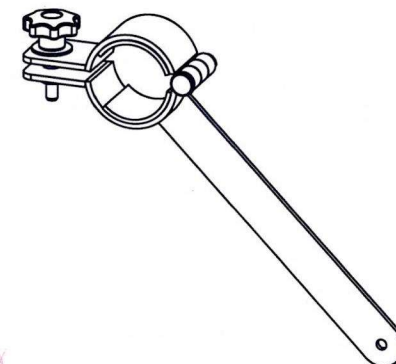
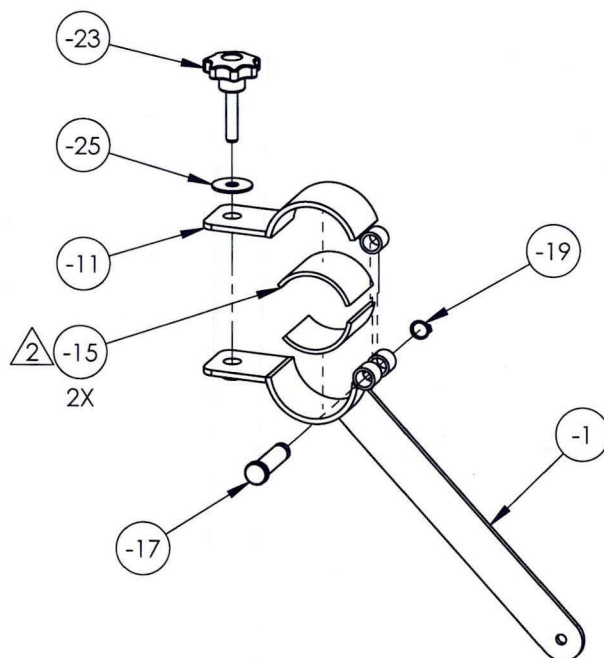
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3855K24	1	4	0
	91090A107	1	49	0
	92735A450	1	6	0
	97633A170	1	93	0
	RBE350A94-2720-00-1	1	1	0
	RBE350A94-2720-00-15	2	0	0

Part Specifications

Specifications could not be found.

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
1		CH'D T/N WAS RBEA94-2720-00 IS RBE350A94-2720-00. -05 ADDED MISSING DIMS FOR R.50, DELETED Ø.236 & MADE HOLE Ø.313 ONLY. -09 ADDED B/O INFO MCMMASTER-CARR #90592A016. -11 DELETED -13 ADDED -5 TO WELDMENT. -13 DELETED.	5/22/14	DJN	RJC
2	15-0063	UPDATED TO NEW DRAFTING STANDARDS. REDESIGNED. CH'D TO STANDARD HARDWARE. -5 REDESIGNED. -7 CH'D DIM WAS Ø.397-.403 IS Ø.374-.375. -9 ADDED DRAWING. -11 REDESIGNED. ADDED -9 TO WELDMENT. -13 REDESIGNED. -15 ADDED DRAWING.	3/16/2015	DPD	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195067 MWS
19-05-14

NOTES:

1. REF. EUROCOPTER T/N: 350A94272000.
2. USE ADHESIVE TO ADHERE TO -1 & -11.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	HANDLE WELDMENT			2
	1		-3		HANDLE	1018		3
	1		-5		BOTTOM TUBE HALF	STEEL TUBE	(Ø2-1/8 X .120 WALL)	4
1	2		-7		HINGE	STEEL TUBE	(Ø1/2 X .065 WALL)	5
1	1		-9		CLAMP TAB	1018		6
X			-11	1	CLAMP WELDMENT			7
1			-13		TOP TUBE HALF	STEEL TUBE	(Ø2-1/8 X .120 WALL)	8
			-15	2	PAD	RUBBER	3/32 THICK, DUROMETER 70 (MCMMASTER-CARR #8568K2) MODIFIED	1
		B/O	-17	1	CLEVIS PIN	S.S.	Ø3/8 X 1-1/2 (MCMMASTER-CARR #92735A450)	1
		B/O	-19	1	EXTERNAL RETAINING RING	STEEL	3/8 (MCMMASTER-CARR #97633A170)	1
	1	B/O	-21		HEX NUT	STEEL	1/4-20, GRADE 5 (MCMMASTER-CARR #95505A601)	2
		B/O	-23	1	KNOB		Ø1-1/4, 1/4-20 X 1-3/16 (MCMMASTER-CARR #3855K24)	1
		B/O	-25	1	WASHER	STEEL	Ø.266 I.D., Ø.875 O.D. (MCMMASTER-CARR #91090A107)	1
ASSY -11	ASSY -1							

DART AEROSPACE	
TITLE HANDLE, ROTARY ADJUSTMENT	
DWG NO. RBE350A94-2720-00	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: WALLRICH APPROVED: <i>J. Gilbert</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 2/20/2015
SHEET 1 OF 9	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					